

Work Order ID 134418-2 split

Wednesday, July 08, 2015 3:13:31 PM

134418

Page 1

Item ID: D3195-041

Revision ID:

Item Name: Bracket

Start Date: 7/07/15 Start Qty: 5.00

Required Date: 7/07/15 Req'd Qty: 5.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: JUL 09 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3195

Rev B

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut blanks: (0.75" x 2.00") x 3.60" long

5 0

DAS

20

9-89

15-08

110

110

HAAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.03

Memo

0.02

Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1 Debur

5 0

DAS

20

9-89

15-08-c

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

5 0

DAS

20

9-89

15-08-c

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Page 2

Item ID: D3195-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 7/07/15 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 7/07/15 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				5	0		DAS 40 9-89 15/08/10
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				5	0		015/08/10
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 12:35								
	FINISH TIME: 1:00								
	OVEN TEMPERATURE: 320°F								

Work Order ID 134418

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Page 4

Item ID: D3195-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 7/07/15 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 7/07/15 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST021</u>	0.00							
190									
Packaging	Memo	0.00				<u>④</u>	<u>JA</u>	<u>AUG 20 2015</u>	
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.01				<u>MLJ</u>		<u>AUG 20 2015</u>	
Quality Control									

DAS
26
9-8920150820 SH

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134418

D3195-041

Start Date: 7/07/15

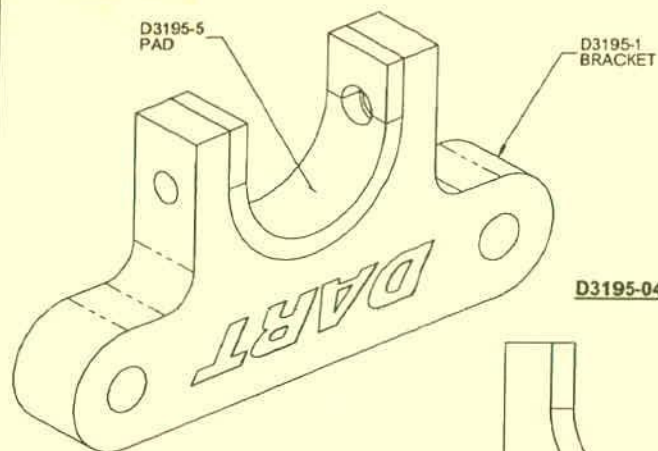
Required Date: 7/07/15

Start Qty: 5.00

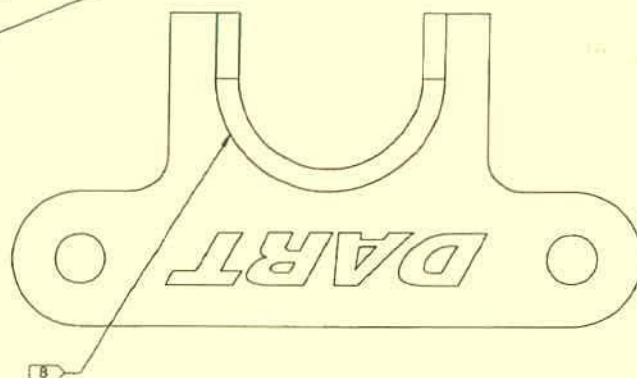
Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5		Manufactured	No			100	Each	4.0000	1	5			DAS
										**		15/08/14	36
													9-89
D3195-5													
Pad													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				* GA	135731								
					119322								
M6061T6B0.750X02.00		Purchased	No			170	f	10.4875	0.3	2			DAS
										**		15-08-05	20
												1.584'	9-89
M6061T6B0 750X02 000													
6061-T6 Bar .750 x 2.00													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT002		10.4875							
				m128437		10.4875							
												1.584'	



D3195-041 BRACKET

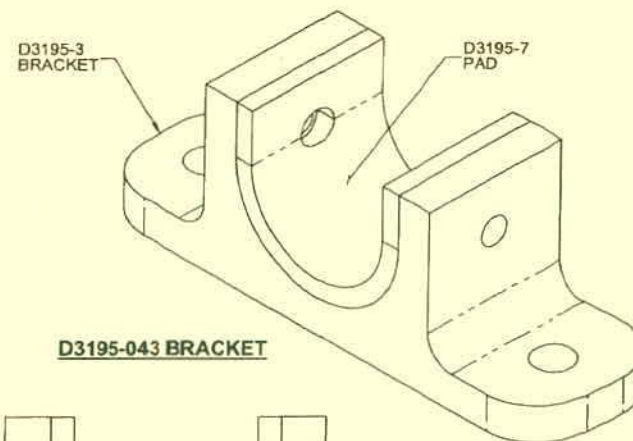


ITEM	QTY -041	P/N	DESCRIPTION
	X	D3195-041	BRACKET
1	1	D3195-1	BRACKET
2	1	D3195-5	PAD

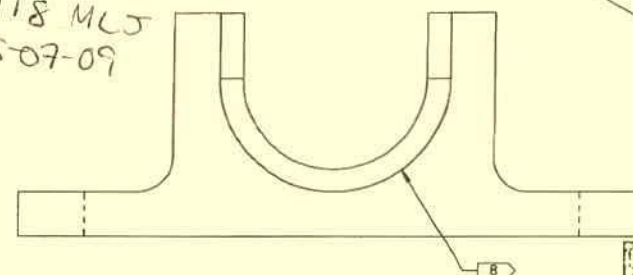
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3195-04X" AND BATCH NUMBER "BXXXXX" PER QSI044 METHOD 6.1
- 7) WEIGHT: D3195-041: 0.15 lbs
D3195-043: 0.14 lbs
- 8) BOND PAD TO BRACKET USING 3M SCOTCH-WELD HIGH PERFORMANCE 1300/1300L (OR EQUIVALENT)

B



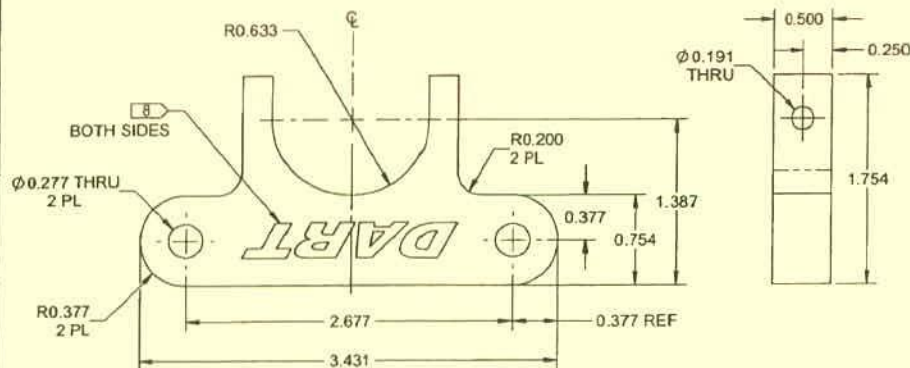
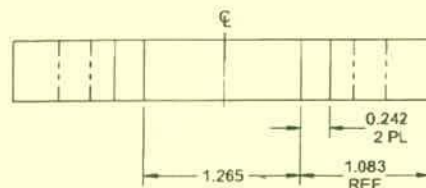
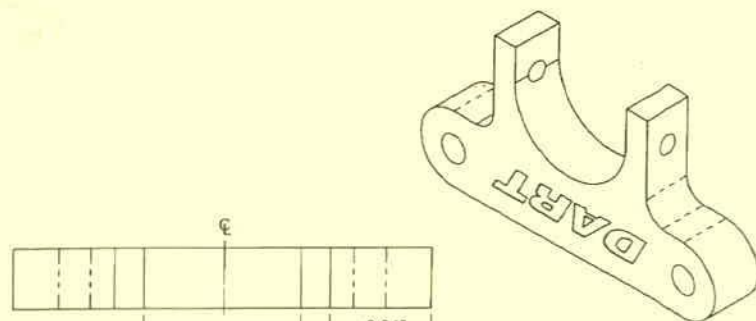
D3195-043 BRACKET



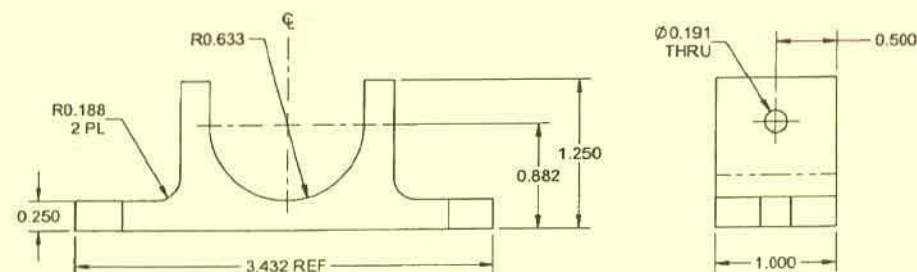
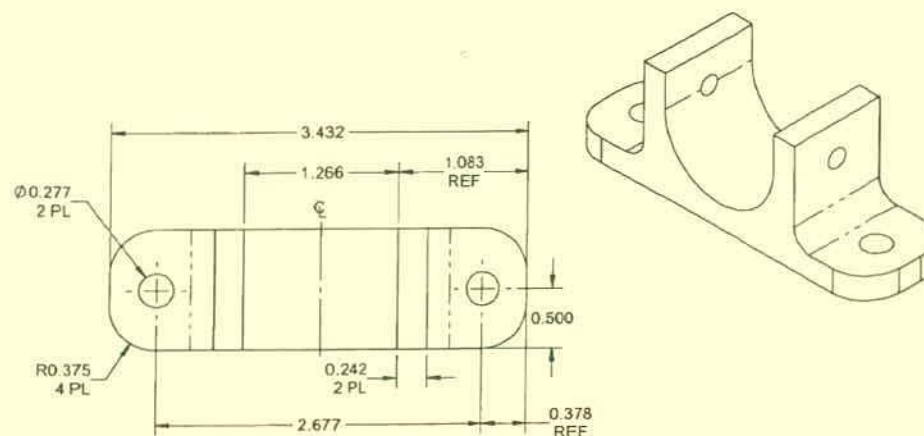
ITEM	QTY -043	P/N	DESCRIPTION
	X	D3195-043	BRACKET
1	1	D3195-3	BRACKET
2	1	D3195-7	PAD

RELEASE
2012-04-30

B	- UPDATED DRAWING FORMAT - ADDED NOTE 8, SHEET 1 - D3195-5 & D3195-7 DIMENSIONS EXTENSIVELY REVISED (B6-3, C3-3) - REF. PART 11-130		RP	12.04.13
A	NEW ISSUE		CP	03.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3195 TITLE BRACKET SCALE NTS		
DRAWN	RP			
CHECKED	A.P.			
MFG. APPR.	[Signature]			
APPROVED	[Signature]	REV. B SHEET 1 OF 3		
DE APPR.	[Signature]	DATE 12.04.13		
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D3195-1 BRACKET

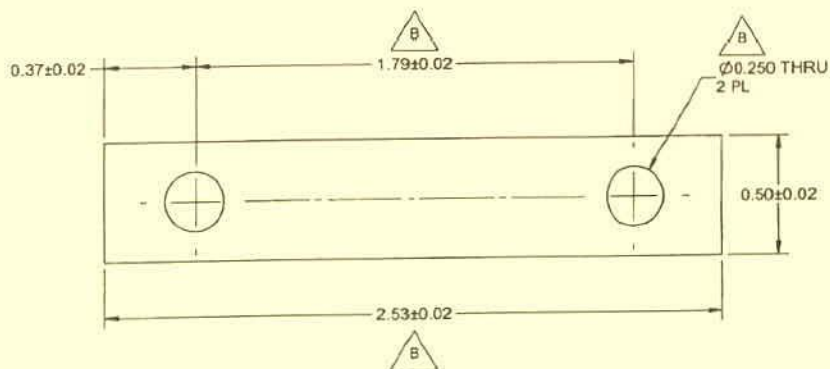


D3195-3 BRACKET

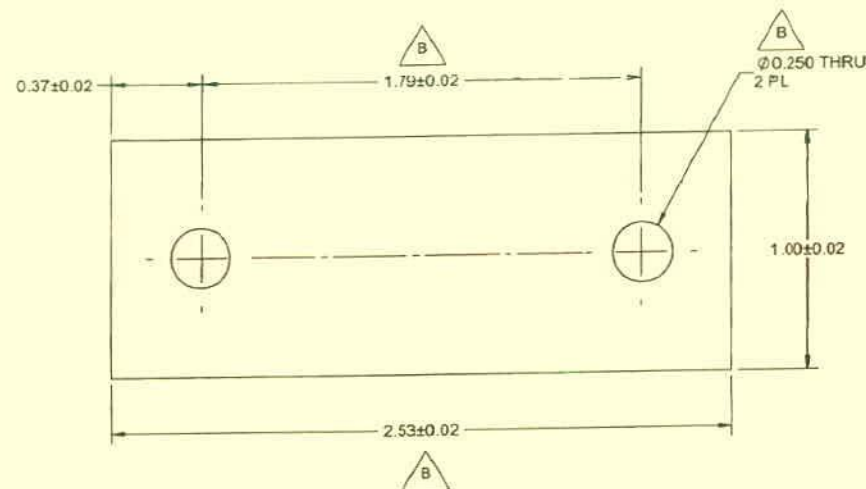
NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3195-1 0.15 lbs
D3195-3 0.14 lbs
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.28 HIGH X 0.005 DEEP LETTERING (TYPICAL BOTH SIDES)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	AS	D3195	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BRACKET	NTS
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D3195-5 PAD



D3195-7 PAD

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/8" THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	CE	D3195	SHEET 3 OF 3
APPROVED	WFO	TITLE	SCALE
DE APPR.	WFO	BRACKET	NTS
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RELEASED
2012-04-30